

450 303

Work Order ID 68103



Page 1

Wednesday, April 06, 2011 2:26:44 PM

Item ID: D2570

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 4/6/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2570

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FA258□Debur

SL 11/5/12
R 11.5.16

202 ✓

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/5/12
R 11.5.16

202 ✓

Pho →

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 11/5/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2570 PAR #: 1/1A Fault Category: Machining NCR: Yes No DQA: 11 Date: 11.05.20
 Resolution: Good as is Disposition: Good as is QA: N/C Closed: 11/05/24

NCR: <u>B68103</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/16	#100	Qty +147 Found by other operator (2nd operator) that all parts have the 0.425" ±.000" Dia measure 0.429". R.C. tool did not add.	OP 11.05.16 DS/OTL	- test Fitted in D2571/D2572 also in D205 skin tube it does fit. - Acceptable	S 11/05/16	11.05.16	OP 11.05.16 DS/OTL	S 11/05/16
		Lack of attention						

NOTE: Date & initial all entries

Work Order ID 68103

Wednesday, April 06, 2011 2:26:44 PM



Page 2

Item ID: D2570

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 4/6/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 2/7

0.00



Packaging

Memo

0.00

Packaging

Run 4/17 (202)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18 20211-05-18 (202)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 06, 2011 2:26:51 PM

Page 1

Work Order ID: 68103

Parent Item: D2570

Parent Item Name: Bushing



Start Date: 4/6/2011

Required Date: 4/13/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP E 02.08.29 Re-format; Removed finishing; Material change KJ
IPP F 07.07.06 rev B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750 		Purchased	No			100	f	65.2100	0.0771	16.23158			
303 Round Bar 0.750													

Location

MAT028

117142

117481

Loc Qty

65.21

65.21

Loc Code

11.025'
4.125'
15.150'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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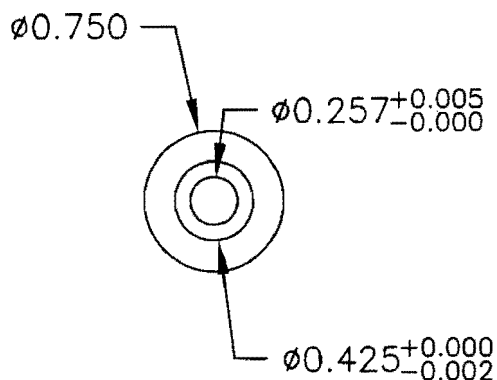
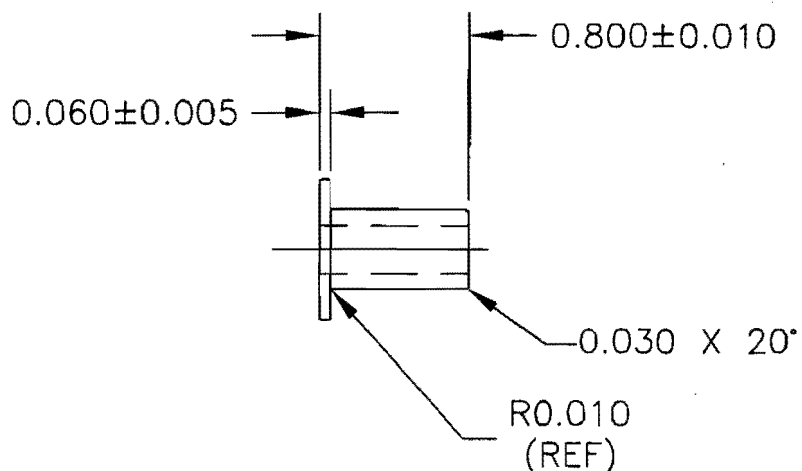
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28 *#***D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68103

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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